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D4776-3

Job Sheet 184548



Part No: D4776-3

Job Qty: 30 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 18-803 DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		11/2/18	0.00	0.00	Start Up Machining-3		MLC 18/10/31
100	Bandsaw	30 pcs		11/2/18	0.00	0.54	Bandsaw1		"
110	CNC Vertical Machining	30 pcs		11/2/18	0.26	26.09	HAAS1-5		"
120	QC	30 pcs		11/2/18	0.00	0.00	QC2 Machining-3		"
130	QC	30 pcs		11/2/18	0.00	0.00	QC8 Machining-3		MLC 18/11/01
140	HandFinish	30 pcs		11/2/18	0.00	0.79	HandFinish1		DR 18/11/01
150	QC	30 pcs		11/2/18	0.00	0.00	QC7-4		SEP 18-11-01
160	Powdercoat	30 pcs		11/2/18	0.00	0.37	Powdercoat1		BL 18-11-01
170	QC	30 pcs		11/2/18	0.00	0.00	QC3		NOV 02 2018 68
180	Packaging	30 pcs		11/2/18	0.00	0.00	Packaging3-2	ST115 00	NOV 02 2018 9-89
190	QC21-SA	30 Ea		11/2/18	0.00	0.00	QC21		21 NOV 02 2018

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

M188951 160 - START TIME: 12:00

TEMP: 320°

FINISH: 12:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	11.0100 ft (.367 ea)	90-Start up Operation	5099812=4.50 5052630=6.71

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	11	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850	
5	Skidtube Clevis	0.510Inches $+ 0.010$ $- 0.000$	0.520 0.510	
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053	
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350	
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970	
10	Skidtube Clevis	0.484Inches $+ 0.006$ $- 0.001$	0.490 0.483	Diameter
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470	
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520	
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140	
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678	
16	Skidtube Clevis	0.397Inches $+ 0.006$ $- 0.001$	0.403 0.396	Diameter
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803	
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115	
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350	
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720	
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS		
		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
				MRB (QSI042) Approval
		Disposition		Completed By
				Lead hand / Supervisor Approval Verification
				QC / QA Coordinator Approval

FAULT CATEGORY		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐